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D4776-5
Job Sheet 184282



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		10/26/18	0.00	0.00	Start Up Machining-3		
100	Doosan	60 pcs		10/26/18	0.05	3.35	Doosan		
120	QC	60 pcs		10/26/18	0.00	0.00	QC8		
130	HandFinish	60 pcs		10/26/18	0.00	0.29	HandFinish1		
140	QC	60 pcs		10/26/18	0.00	0.00	QC7-4		
150	Packaging	60 pcs		10/26/18	0.00	0.00	Packaging3-2		
160	QC21-SA	60 Ea		10/26/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-Turn as per Folio and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	FM138/09.0 513/8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	30	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100	.126	
2	Spacer	0.250Inches ± 0.030	0.280 0.220	.2475	
3	Spacer	0.625Inches ± 0.010	0.635 0.615	.625 Diameter	Ray 312
4	Spacer	0.438Inches ± 0.010	0.448 0.428	.439 Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	.206 Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval		
Description Work Order Deviation			Disposition			
			Completed By			
			Lead hand / Supervisor Approval Verification			
			QC / QA Coordinator Approval			
Root Cause		1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S119996 Part: D4776-5 Job No: 184282 Serial No/Batch: S119996 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's				
Environment ☐	No Re-verification ☐					Pressure/Forced ☐
Design ☐	Operator ☐					Bending ☐
Doc/Data ☐	Offset/Setup ☐					Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐					Cracks ☐
Handling/Pre ☐	Training ☐					Crimp/Kink/Ripple/Wave ☐
Material ☐	Use for Testing ☐					Cuffs ☐
Internal Transport ☐	Poor Information ☐					Crushing ☐
Tribal Knowledge ☐	Rushing ☐					Heat Treat ☐
LOA ☐	Product Improvement ☐					Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐				
Past Expiry Date ☐	Manufacturing Process ☐					
Misidentified ☐	Past Due ☐	OTHER : ☐				